



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200
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D350-636-023
Job Sheet 187913



7802

Part No: D350-636-023

Job Qty: 1 ea

Part Name: AS350/355 - Skidtube - Standard w/ Heavy-Duty Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/18

Job Tracking No:

Due Date: 1/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4168-051 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF.JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/28/19	1/28/19	0.00	0.00	Start Up Skidtubes-1		BE
110	Skidtubes	1 pcs	1/28/19	1/28/19	0.00	5.25	Skidtubes-1		BE DAS
120	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC10		38 DAS
130	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC5		9-89 38
140	HandFinish	1 pcs	1/28/19	1/28/19	0.00	0.99	HandFinish1		9-89
150	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC7-2		MG
160	Skidtubes	1 pcs	1/28/19	1/28/19	0.00	5.25	Skidtubes-1		DD, BE, TF
170	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC10		38 DAS
180	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC5		9-89 38
190	HandFinish	1 pcs	1/28/19	1/28/19	0.00	0.99	HandFinish2		DR 19/01/19
200	SprayPaint	1 pcs	1/28/19	1/28/19	0.00	0.91	Spray Paint		AS 19-1-27
205	Outsource	1 pcs	1/28/19	1/28/19			ATE003-VC	5	UR
210	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC14		19-1-30
230	HandFinish	1 pcs	1/28/19	1/28/19	0.00	0.99	HandFinish4		19-1-31
240	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC5		19-1-31
250	Packaging	1 pcs	1/28/19	1/28/19	0.00	0.00	Packaging1-3		JAN 3 1 2019
260	QC	1 pcs	1/28/19	1/28/19	0.00	0.00	QC4		DAS 21
270	Packaging	1 pcs	1/28/19	1/28/19	0.00	0.00	Packaging3-1		9-89 DAS
275	DC	1 pcs	1/28/19	1/28/19	0.00	0.00	DC		9-89
280	QC21-FG	1 Ea	1/28/19	1/28/19	0.00	0.00	QC21		21 JAN 3 1 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 4 (D4168-5 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DE-DE. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "DA" 6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail DA to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 1389189 9- Grind welds flush as per Dwg D4168 160 - 1-Open up holes using hole saw of Detail DB and ground handling section EN-EN to 0.625" (total of 8 holes per side) as per dwg D4168. Open wearplate holes to size as per dwg (4 holes per sides), section EP-EP 4-Chamfer holes of Detail DB, ground handling section AL-AL per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 3128386 exp: date: 03/01/19 ***ATTN: USE I-BEAM LOCATION

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job No. _____ Part No. _____ Date _____ Sequence # _____ Description Work Order Deviation _____ Part: D350-636-023 Job No: 187913 Serial No/Batch: S141738 Revision: C/K Inspector: _____ Exp Date: _____ Instructions: TC STC SH99-7 Issue 2 of 4, STC SR00646SE 15/10/28, EASA STI Container No: S141738 Uart Aerospace Ltd. 1270 Aberdeen Street, Chesham, ON K64 1K7 TEL: Y 813 692-5200 Email: sales@dartaero.com www.dartaerospace.com		DEPARTMENT/PROCESS		
		Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
		Disposition		
		Completed By		
Lead hand / Supervisor				
QC / QA Coordinator				
Root Cause		FAULT CATEGORY		
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details: _____				

AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet) A/R Aluminum Rod batch: 138989 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section EN-EN 12- C'bore section CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: TF 13- Deburr holes, ensure tube is free of all scratches before sending to paint. *****

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: 138976

2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5146086

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5128386 EXP DATE: 14-6-3

5-Coat all exposed fasteners with "LPS Procyon" batch: M133C40

250 - If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Identify and pack for shipping as per PPPD350-636-023 Location :FG071

275 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-023 CHG 001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	007825
D2744	Cap	1 pcs (1 ea)	90-Start up Operation	5129373
D2739	350 I-Beam	1 Ea (1 ea)	160-Skiddtubes	5060499
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skiddtubes	5140949
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-HandFinish	5133725 (3) 5133730 (5)
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5058138
AN3C36A	Bolt	4 Ea (4 ea)	230-HandFinish	511712
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	FM136658-1
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5142453
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5142145
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5142143
D3488-3	Blade Fitting, LH	1 Ea (1 ea)	230-HandFinish	5137492421
D3631-1	Washer	8 pcs (8 ea)	230-HandFinish	5148053
D3873-1	Bushing	7 Ea (7 ea)	230-HandFinish	5058407
D4154-041	Wearplate Assembly	1 Ea (1 ea)	230-HandFinish	5137512
D4170-1	Bushing	4 Ea (4 ea)	230-HandFinish	5145974
D4171-1	Bushing	1 pcs (1 ea)	230-HandFinish	5131023
MS21043-3	Nut	5 Ea (5 ea)	230-HandFinish	5061056
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5099569
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	510936K1
NAS1149C0332R	Washer	4 Ea (4 ea)	230-HandFinish	5104046
NAS1149C0363R	Washer	9 Ea (9 ea)	230-HandFinish	5124666
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5135100
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5076017-2
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging	5083559
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5064011
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5084120
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5129315
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5104046
				5133789

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	11	0
	D2744	1	10	0
160-Skiddtubes	D2739	1	0	0
	D2743	8	48	0
230-HandFinish	ALS4-1032-225	4	1,171	0
	AN3C34A	1	26	0
	AN3C36A	4	444	0
	AN3C6A	4	132	0
	AN6C44A	4	76	0
	AN8C35A	1	27	0
	D2745	8	226	0
	D3488-3	1	6	0
	D3631-1	8	425	0
	D3873-1	7	141	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lqst/Missing ☐ Misread			
Other/Details: _____					

250-Packaging

D4154-041	1	0	0
D4170-1	4	52	0
D4171-1	1	8	0
MS21043-3	5	796	0
MS21043-6	4	89	0
MS21083C8	1	98	0
NAS1149C0332R	4	2,333	0
NAS1149C0363R	9	867	0
NAS1149C0832R	1	370	0
NAS1515H3L	4	462	0
AN3C37A	1	59	0
AN8C21A	2	57	0
D2741	1	70	0
MS21083C8	2	98	0
NAS1149D0863J	2	160	0

Part Specifications

Specifications could not be found.

Plex 12/20/18 11:08 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X					D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X				D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X			D4168-044	350 SKIDTUBE ASSEMBLY, RH
				X		D4168-051	350 SKIDTUBE ASSEMBLY, LH
					X	D4168-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG ASSEMBLY
8	8					D3492-043	PLUG ASSEMBLY
		8	8			D3492-045	PLUG ASSEMBLY
8	8	8	8	8	8	D3631-1	WASHER
7	7	7	7	7	7	D3873-1	BUSHING
1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1						D4168-1	SKIDTUBE WELDMENT, LH
	1					D4168-2	SKIDTUBE WELDMENT, RH
		1				D4168-3	SKIDTUBE WELDMENT, LH
			1			D4168-4	SKIDTUBE WELDMENT, RH
				1		D4168-5	SKIDTUBE WELDMENT, LH
					1	D4168-6	SKIDTUBE WELDMENT, RH
4	4	4	4	4	4	D4170-1	SPACER
1	1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	4	ALS4-1032-225	INSERT
1	1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	4	AN3C36A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
5	5	5	5	5	5	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
4	4	4	4	4	4	NAS1149C0332R	WASHER
9	9	9	9	9	9	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.3
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 lbs
D4168-051/-052 = 31.9 lbs
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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NO. 187913 HCS

1872-20

C	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D4168-5/-6 (ZN B5-1, SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11, D2-12, D2-13, D2-14); ADDED NOTES 13, 14 (ZN C4-1); NAS1149C0363R WAS AN960C10 (ZN A5-1, C6-11, C7-11, D8-11, C6-12, C7-12, D8-12, C6-13, C7-13, D8-13, C6-14, C7-14, D8-14); NAS1149C0332R WAS AN960C10L (ZN B1-11, B1-12, B1-13, B1-14); NAS1149C0832R WAS AN960C816L (ZN C1-11, C1-12, C1-13, C1-14)	ZF	18.03.01
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
DATE	18.03.01		

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D4168**
SHEET 1 OF 16
SCALE
NTS

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RELEASED

2010 OCT 19
2010 10-930

APPROVED

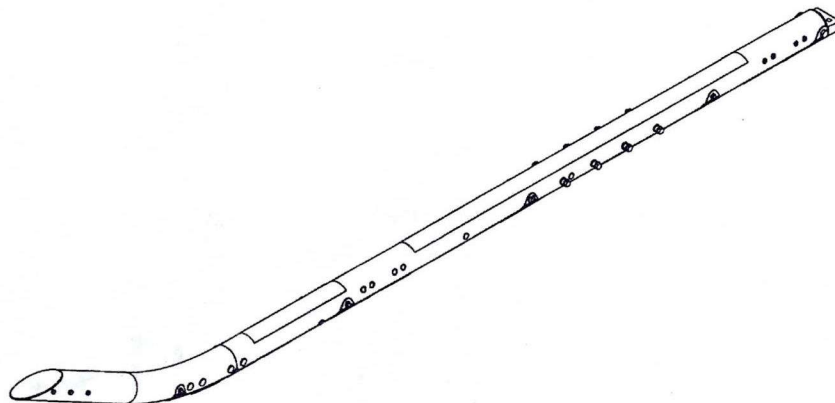
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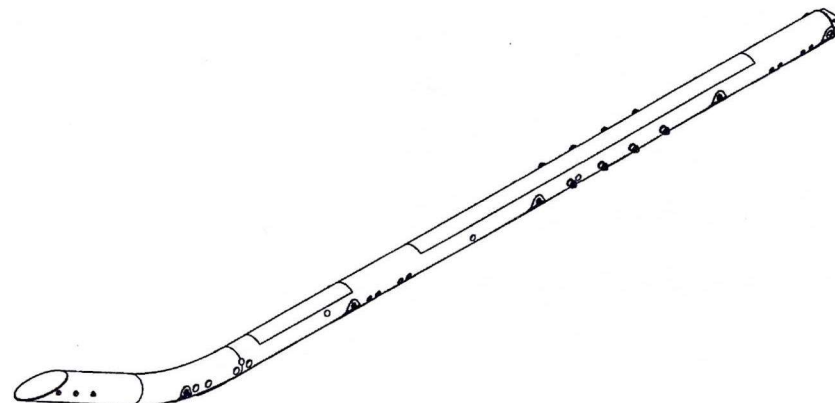
C

B

A



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

D

C

B

A

RELEASED

2018 OCT 19 *ap*

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 2 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

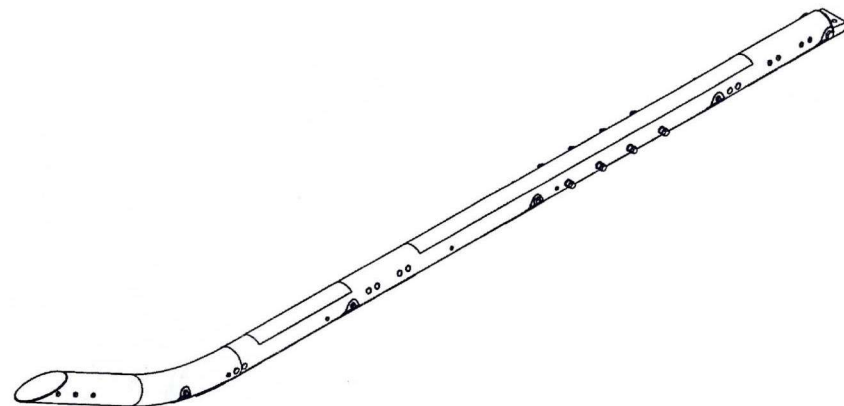
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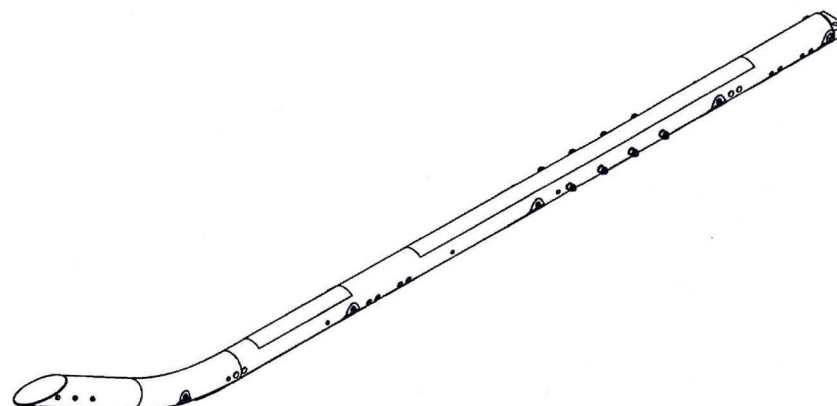
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A



D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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8 7 6 5 4 3 2 1

D

C

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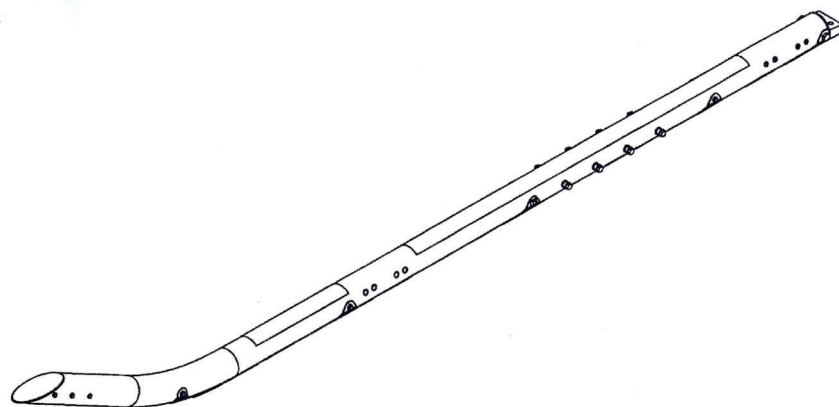
A

D

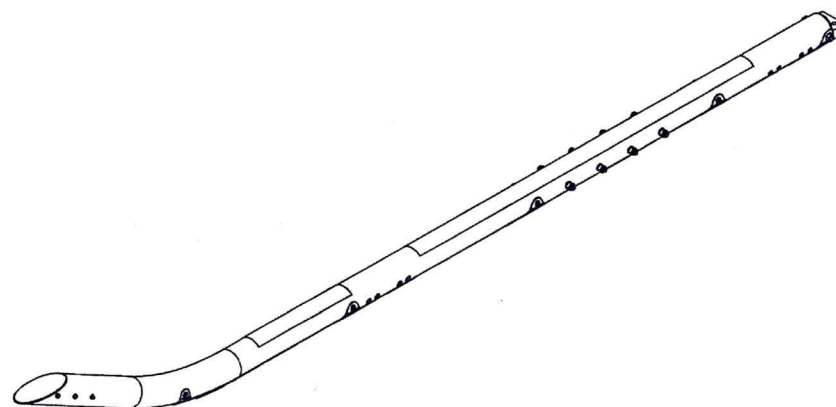
C

B

A



D4168-051 350 SKIDTUBE ASSEMBLY, LH



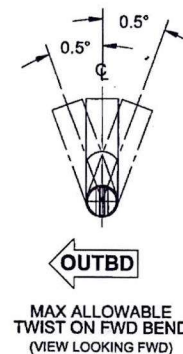
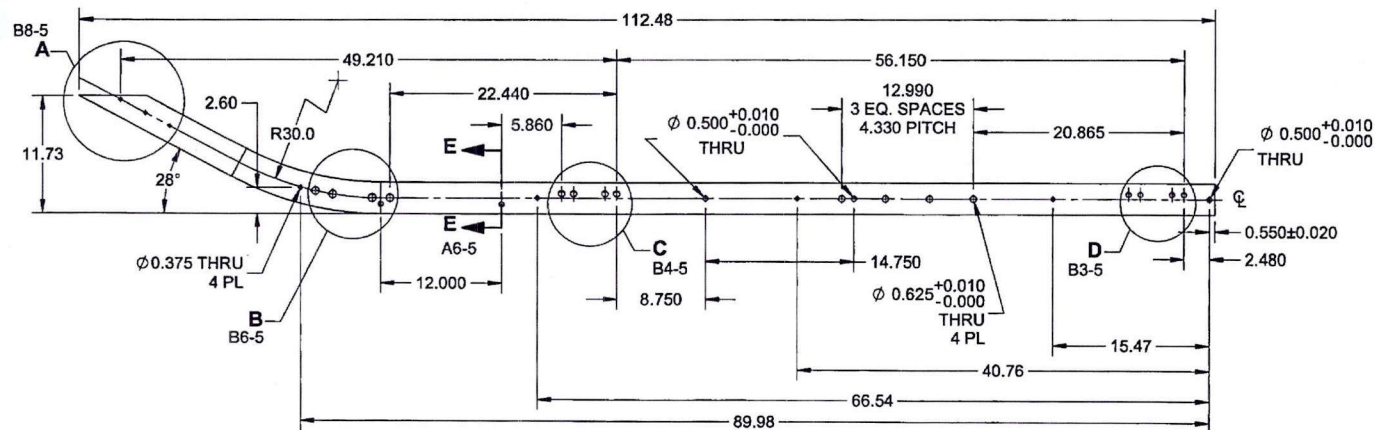
D4168-052 350 SKIDTUBE ASSEMBLY, RH

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2019 OCT 19

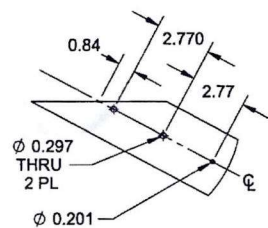
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CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 4 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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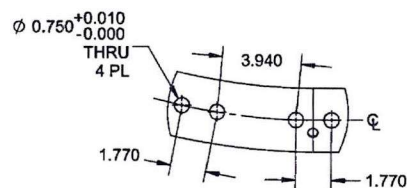
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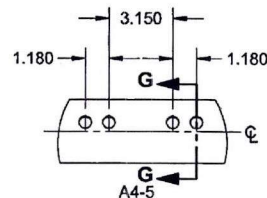
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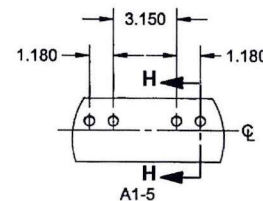
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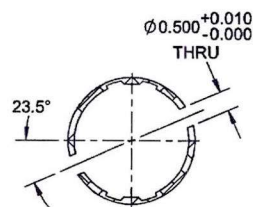
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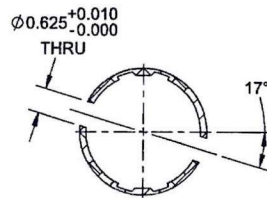
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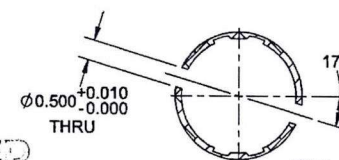
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SECTION E-E
SCALE 4X, 2 PL



SECTION G-G
SCALE 4X, 4 PL



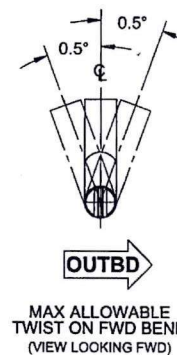
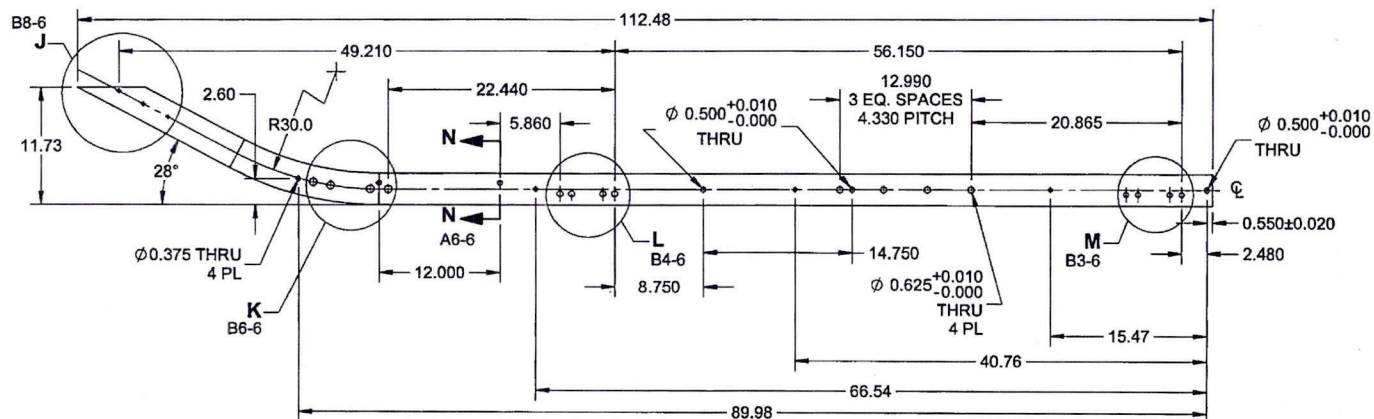
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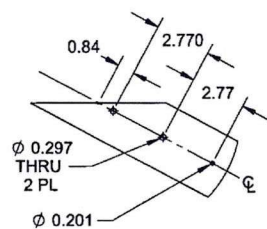
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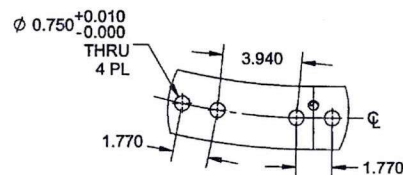
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CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 5 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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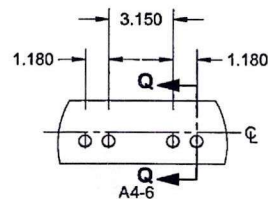
D4168-2 RH SKIDTUBE



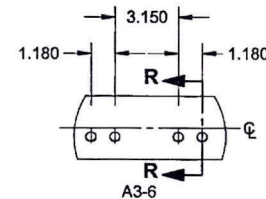
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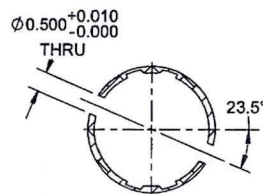
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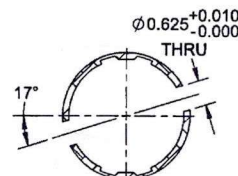
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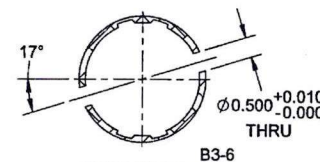
DETAIL M
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SECTION N-N
SCALE 4X, 2 PL



SECTION Q-Q
SCALE 4X, 4 PL



SECTION R-R
SCALE 4X, 4 PL

APPROVED

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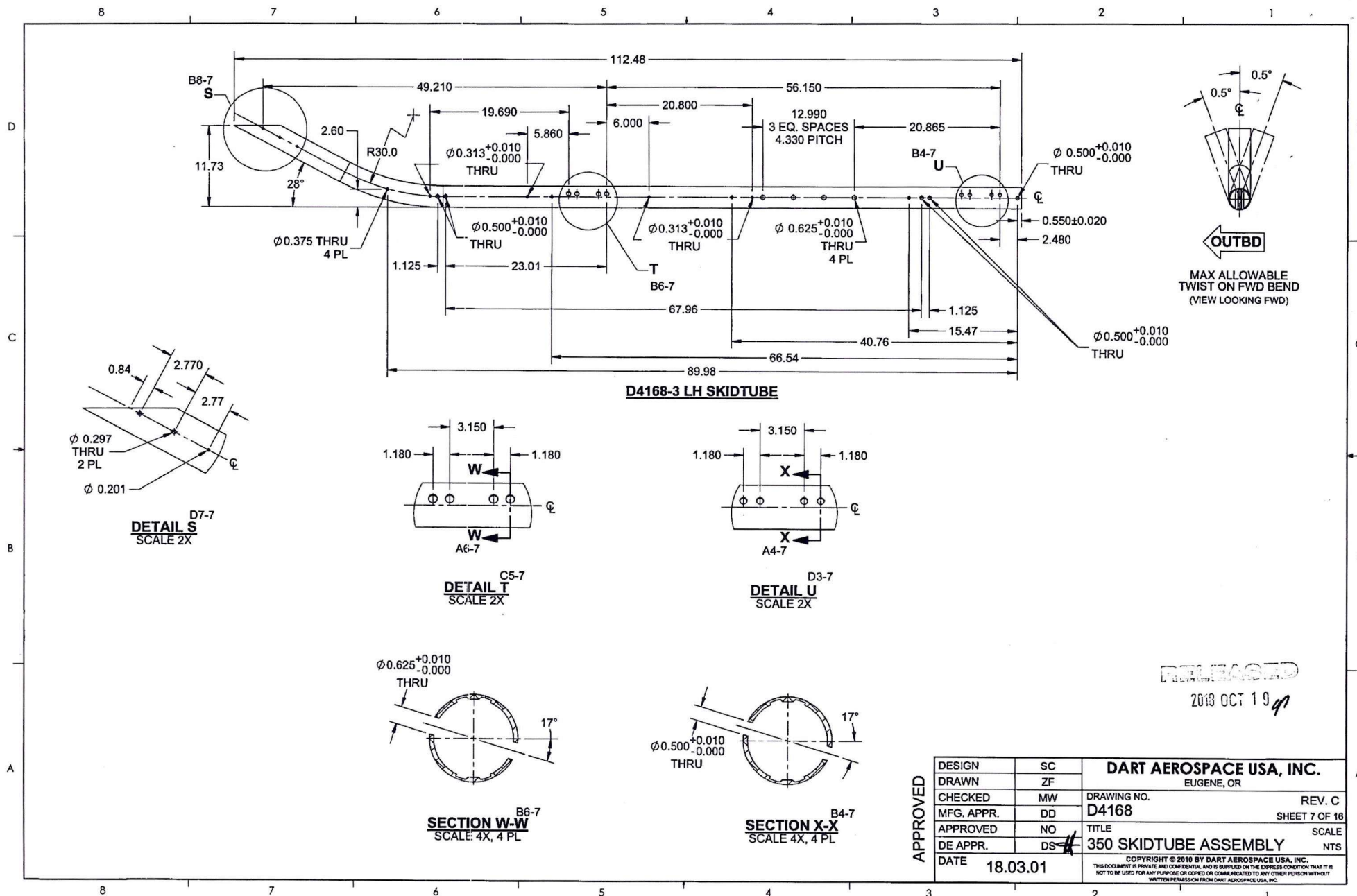
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EUGENE, OR

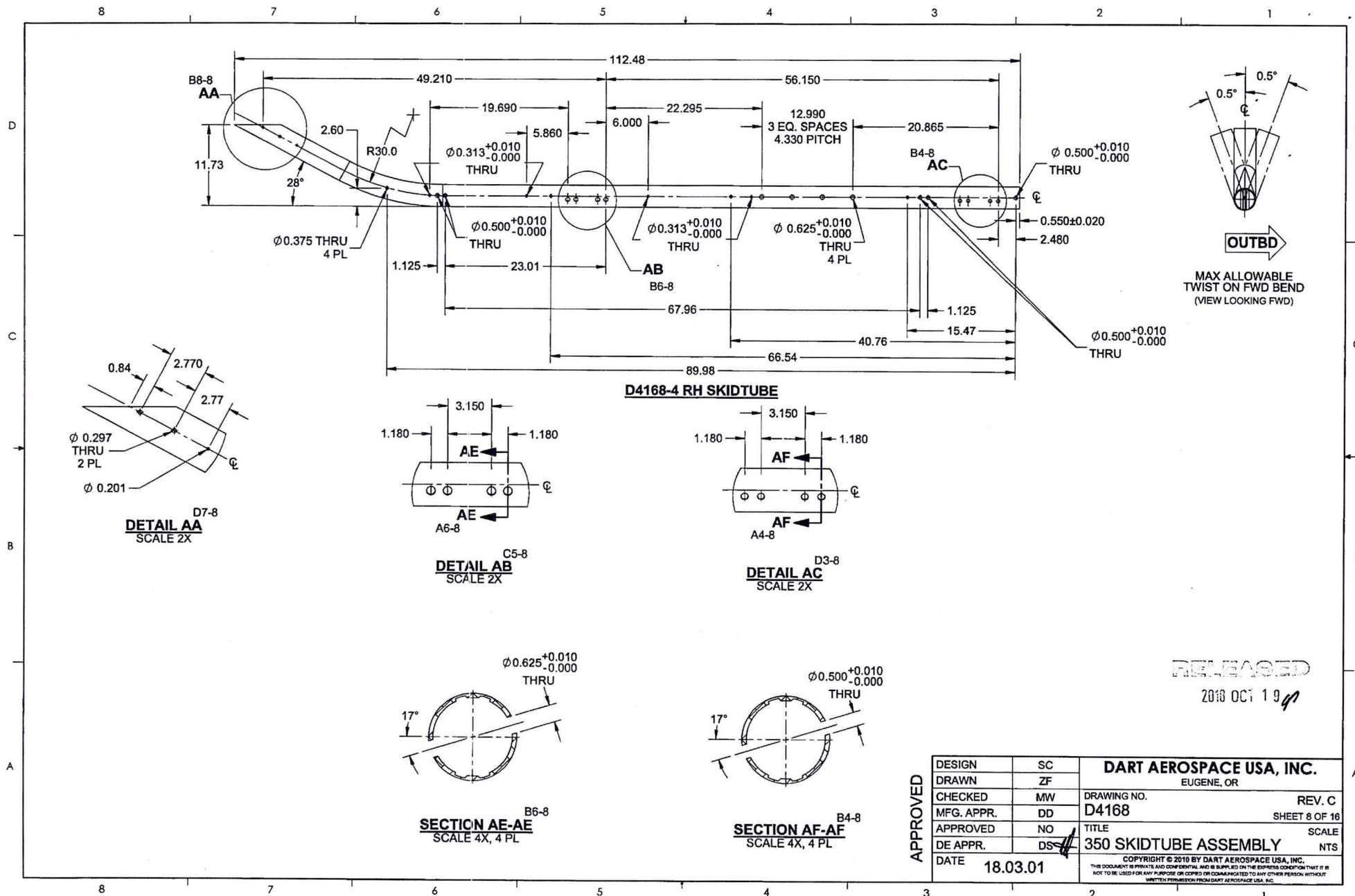
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SHEET 6 OF 16
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

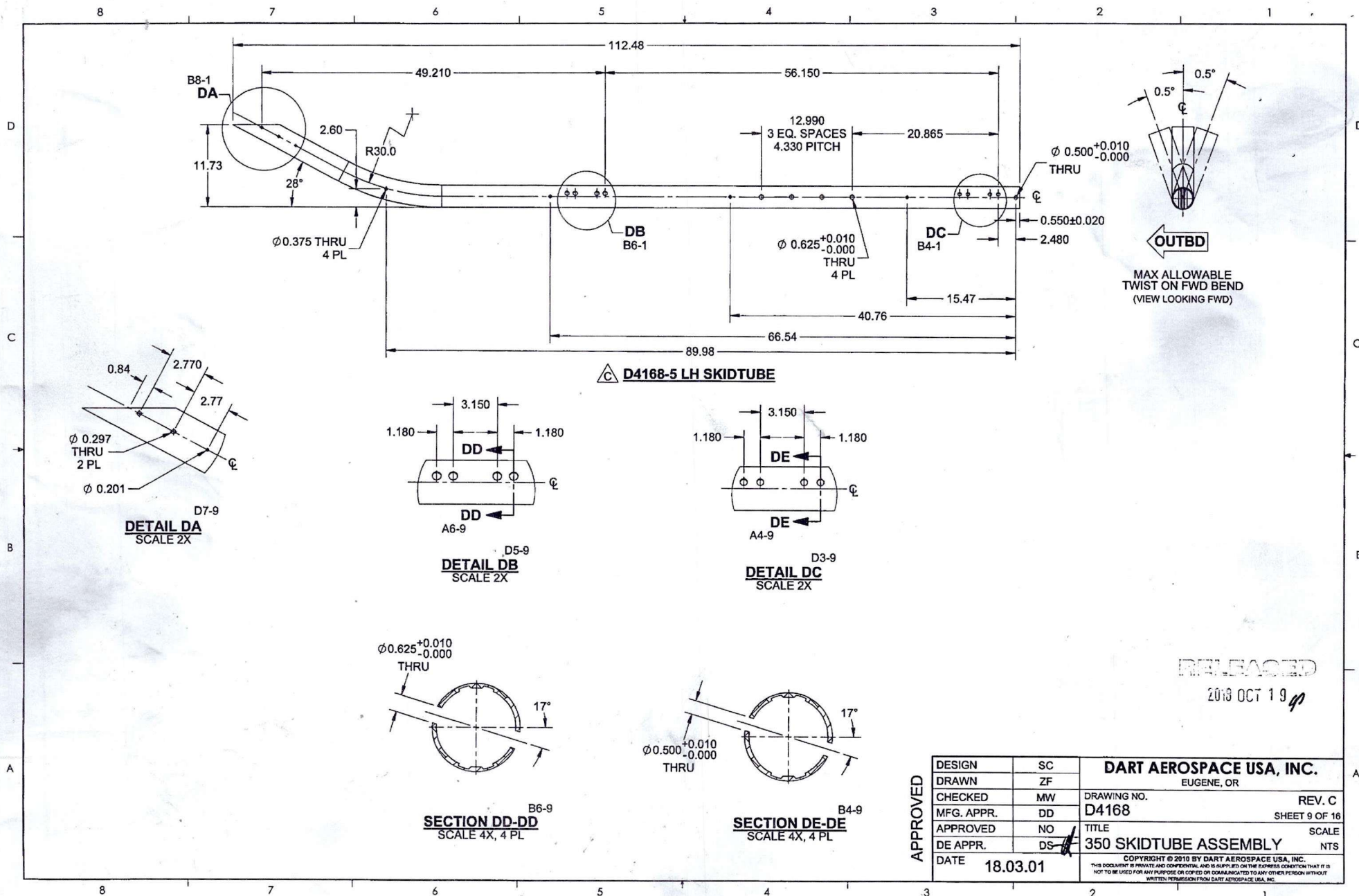
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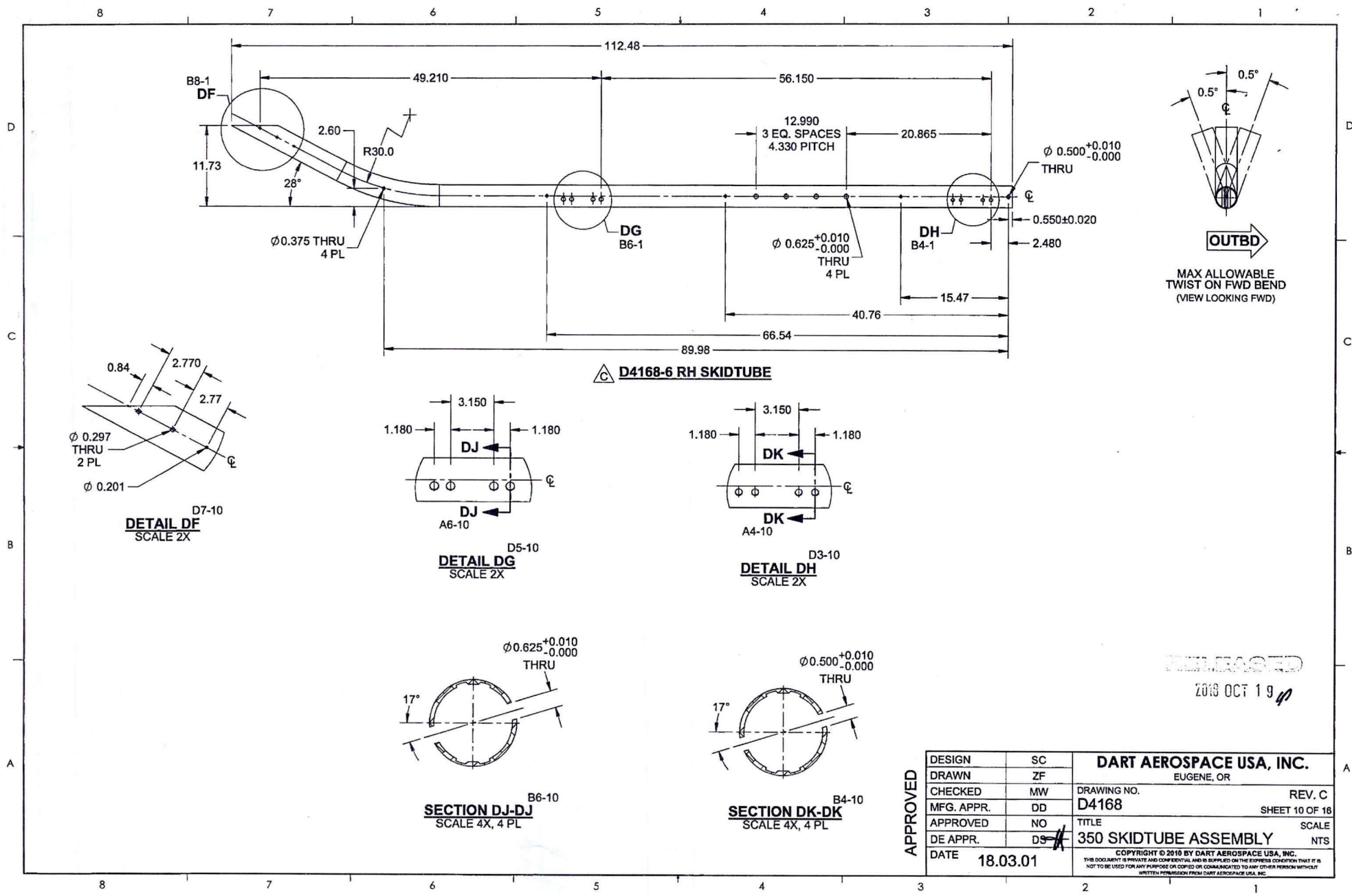
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2010 OCT 19

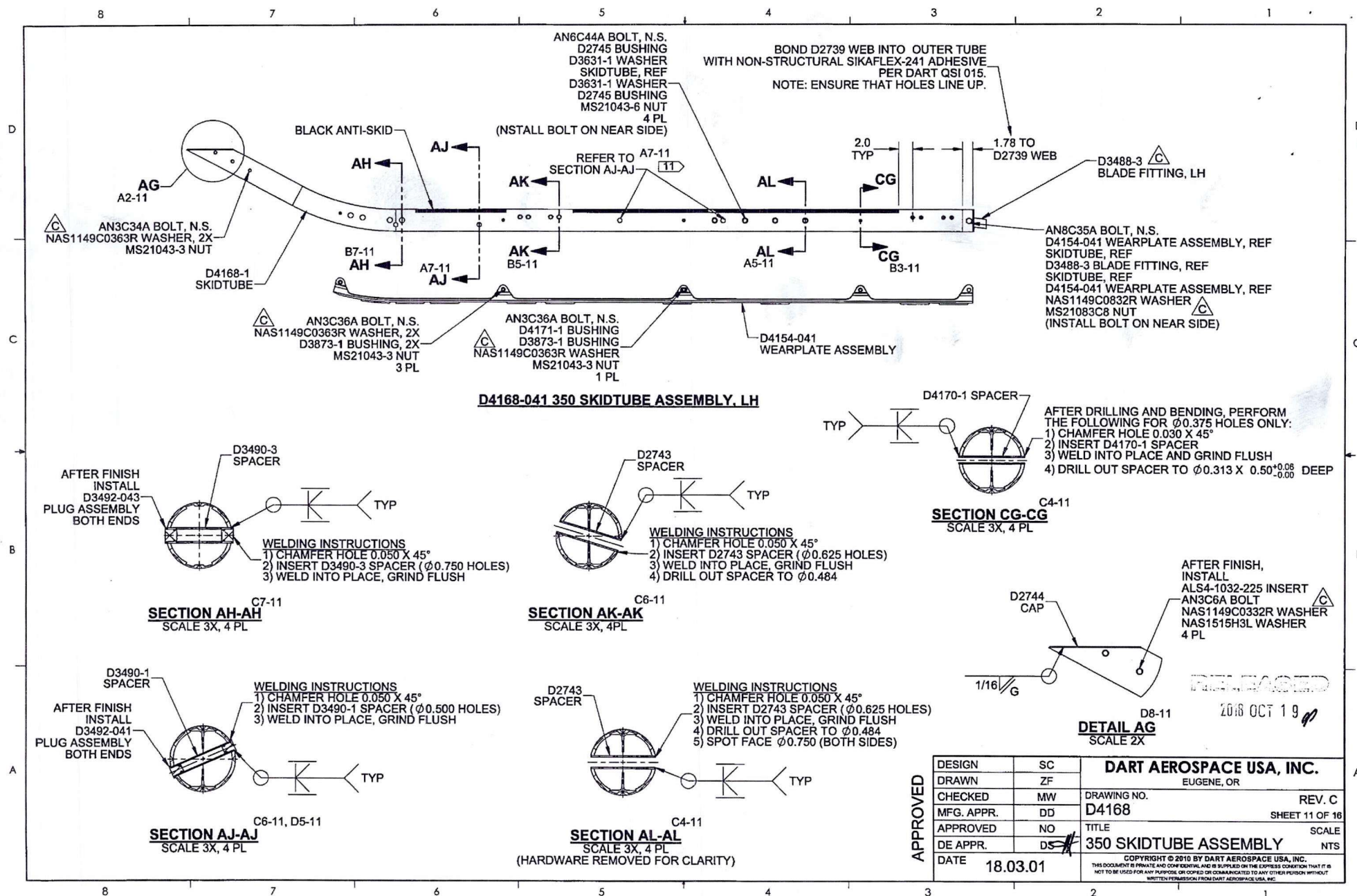


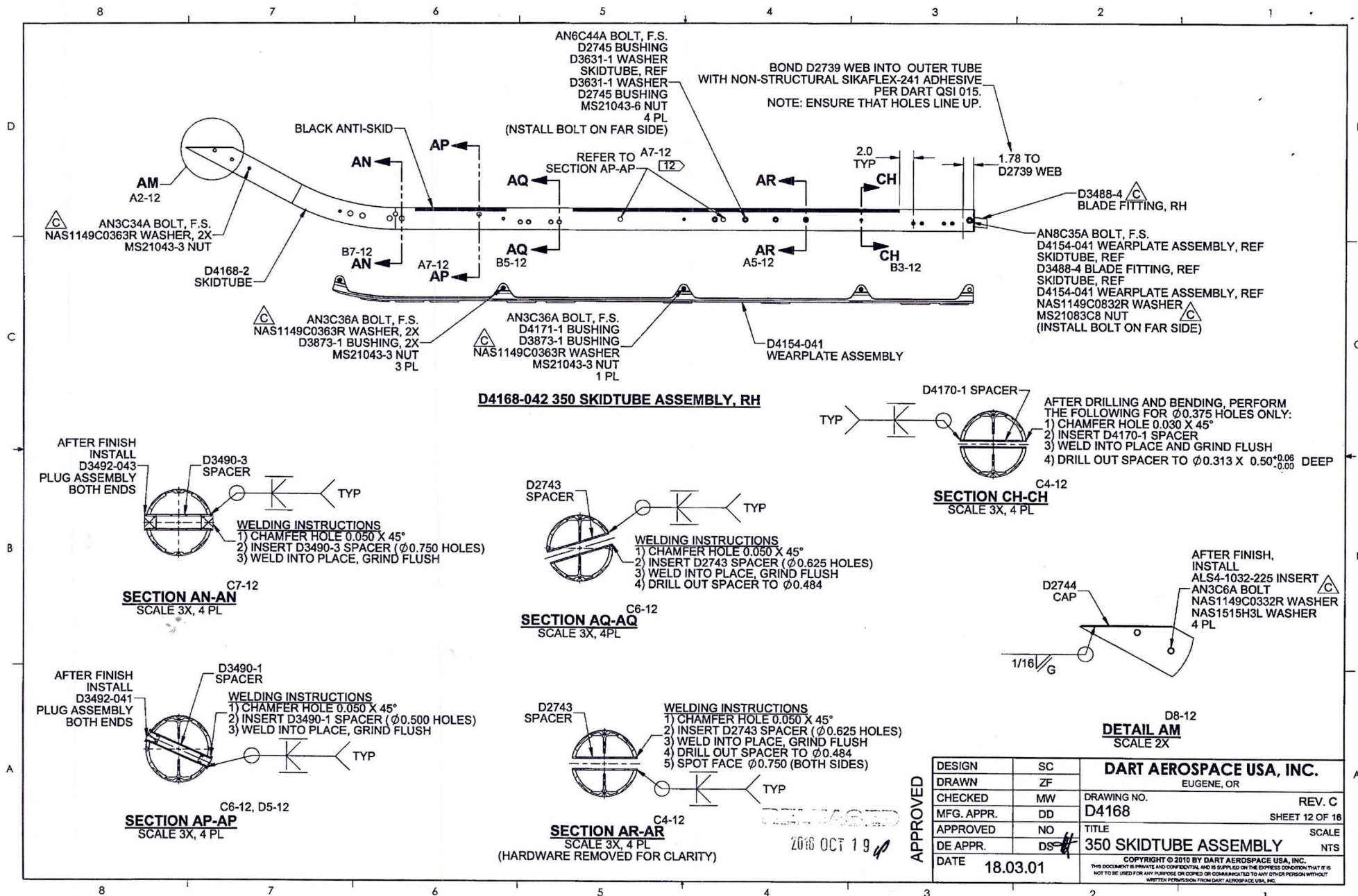


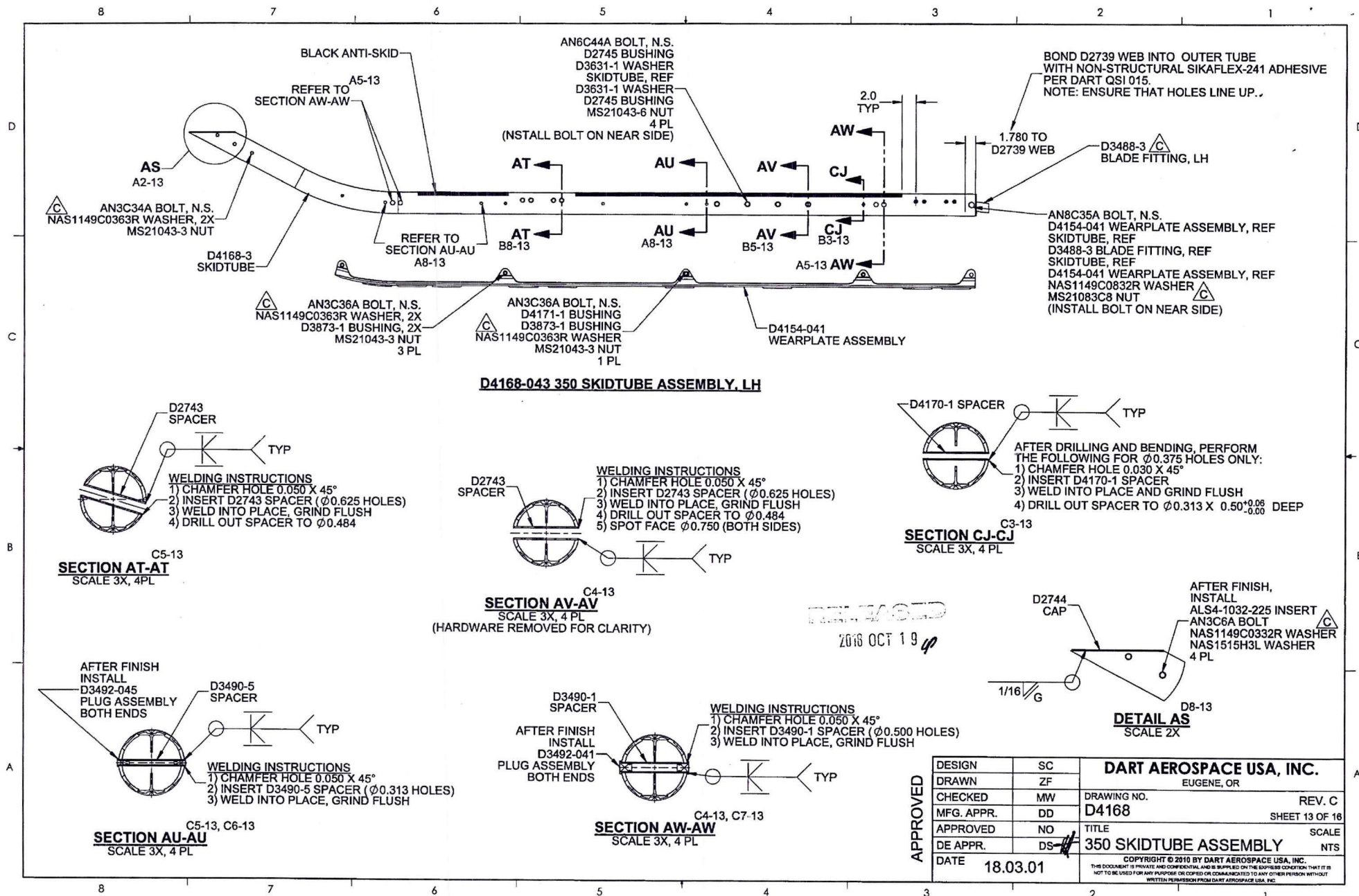


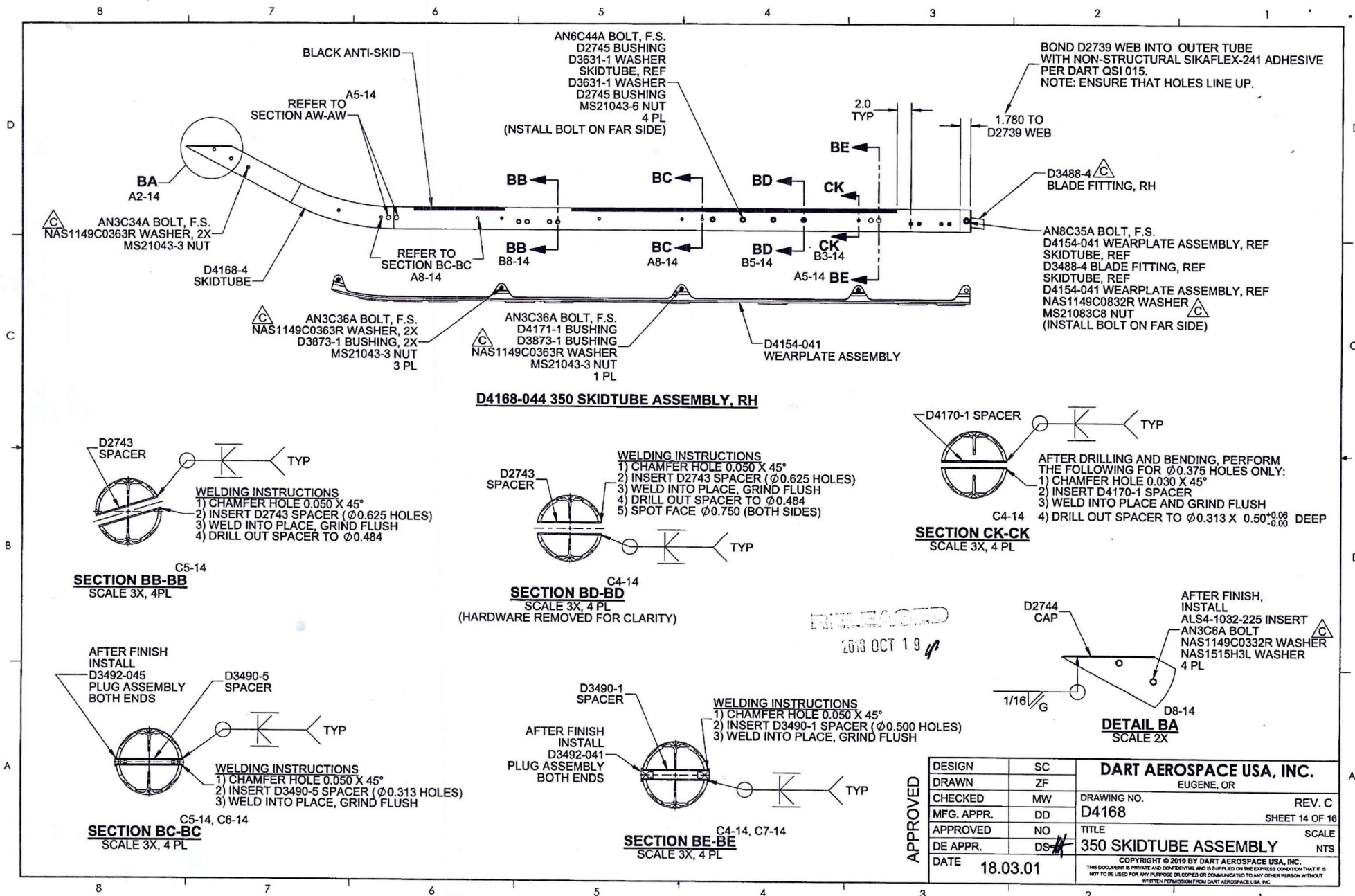


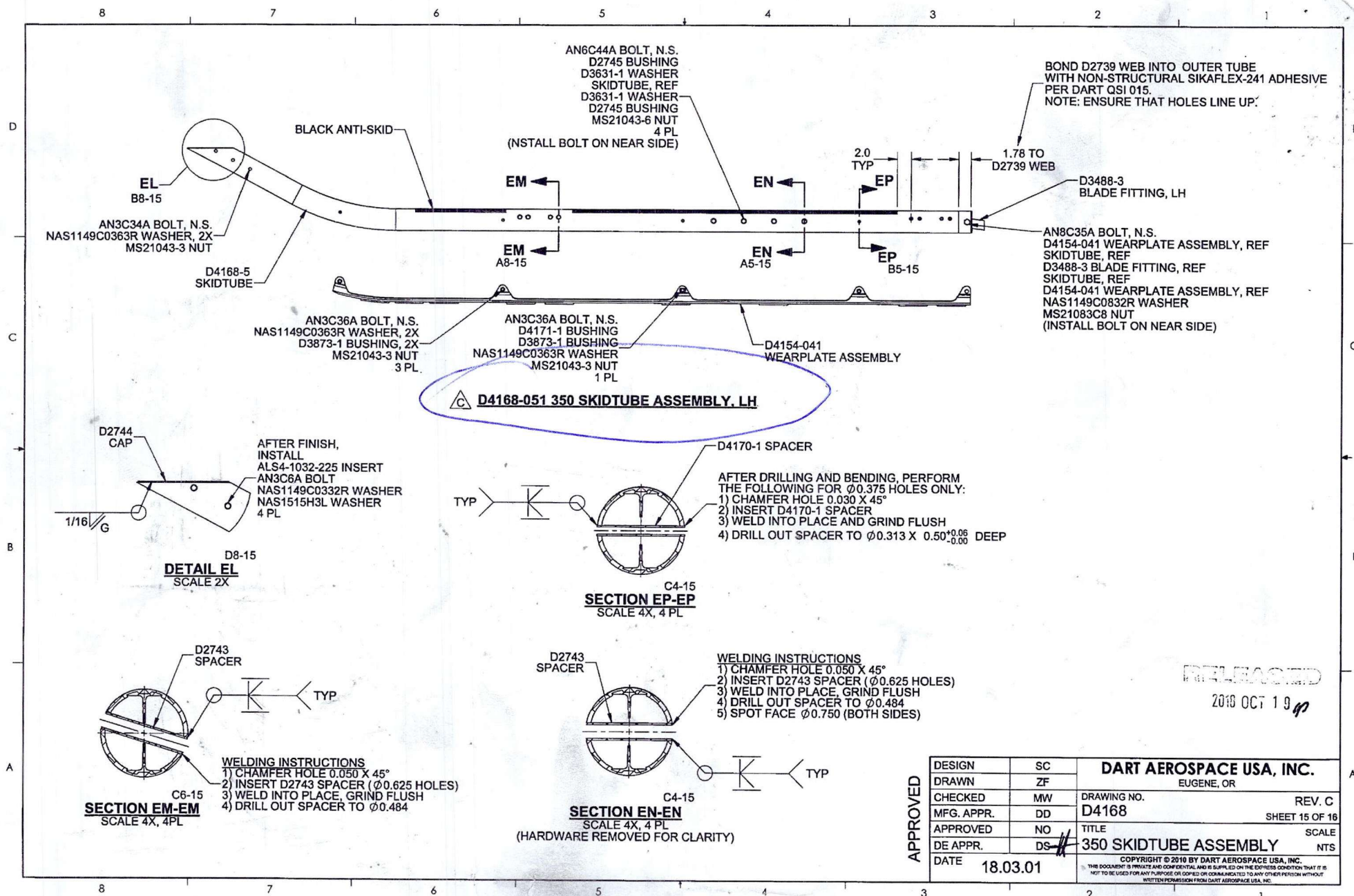
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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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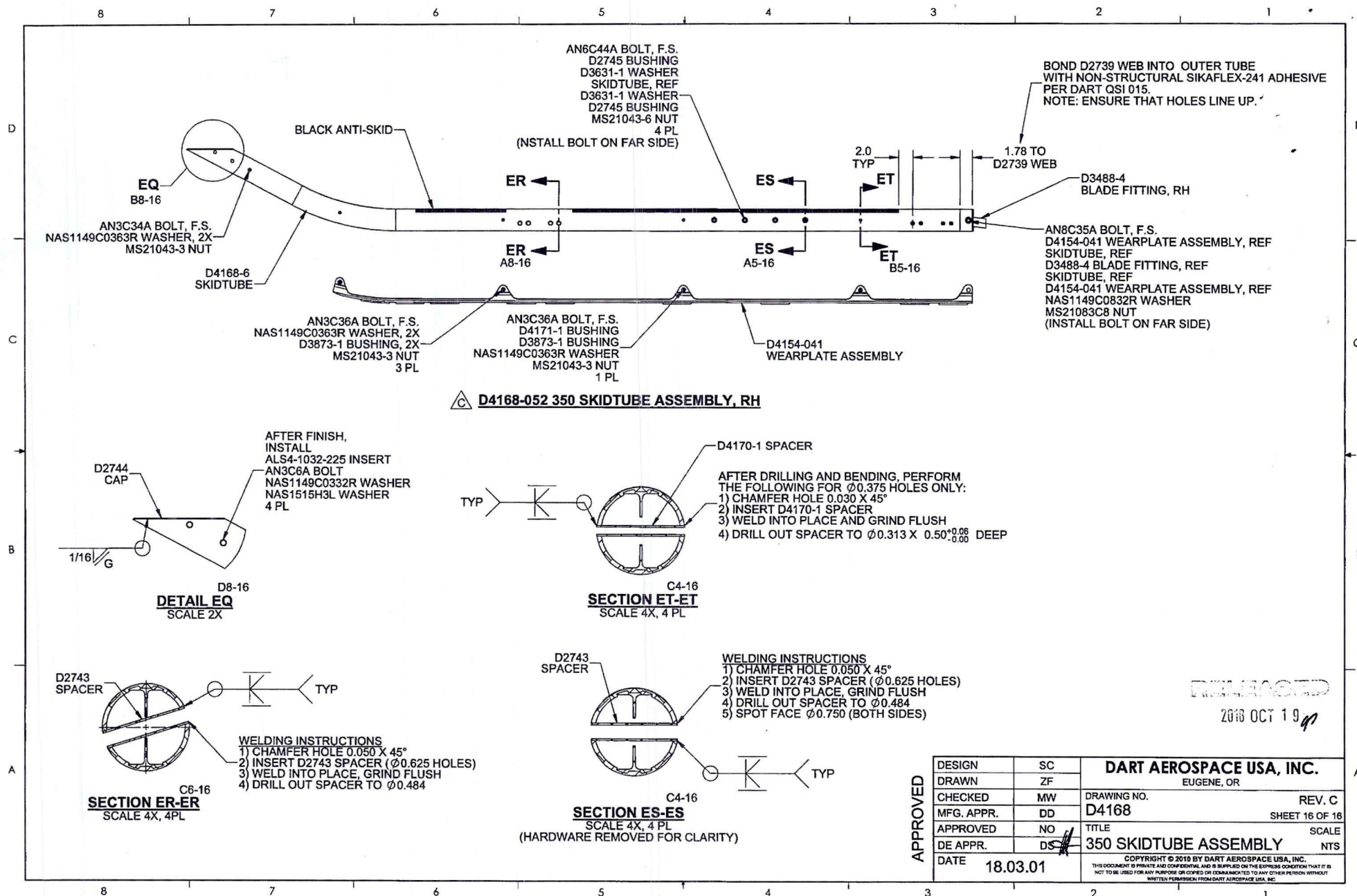












SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

RELEASED
2012-01-11

E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3. UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

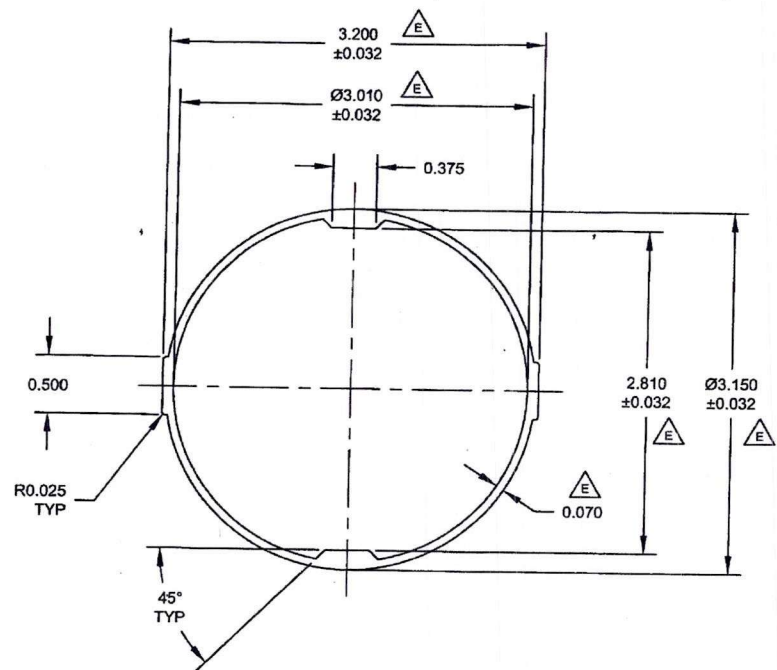
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REV. E
SHEET 1 OF 3
SCALE NTS

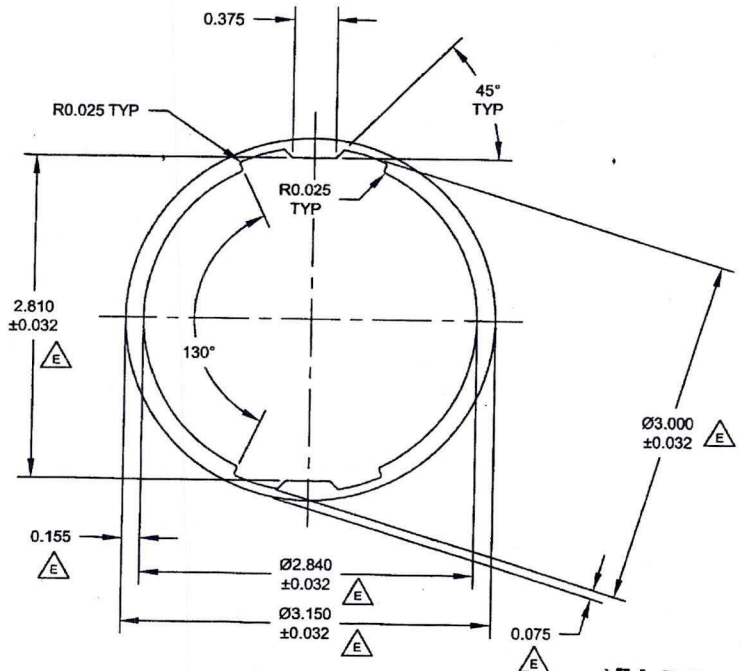
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8 7 6 5 4 3 2 1

D
C
B
A



D2600-1 EXTRUSION

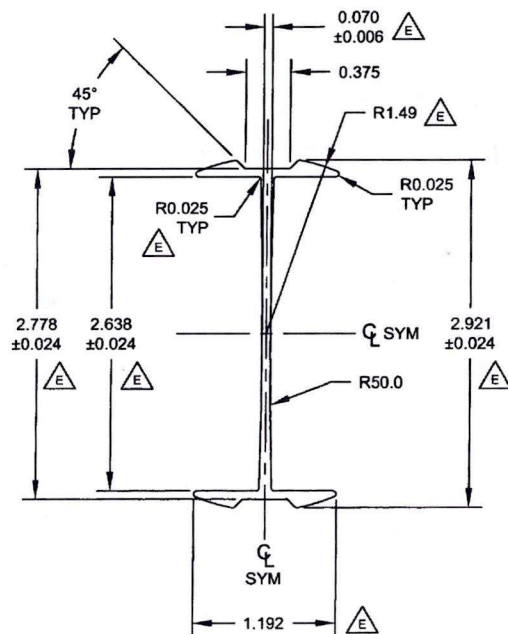


D2600-3 EXTRUSION

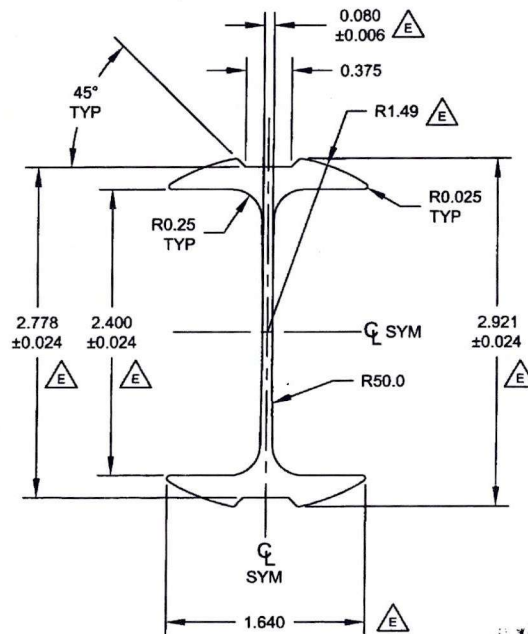
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2012-01-11

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CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	E	D2600	SHEET 2 OF 3
APPROVED	WAS	TITLE	SCALE
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8 7 6 5 4 3 2 1



D2600-5 EXTRUSION



D2600-7 EXTRUSION

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11-10-18

DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	EL	D2600	SHEET 3 OF 3
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